

Date: Wednesday, 9/12/2007 12:14:19 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	34624		
Estimate Number	12736		
P.O. Number	N/A	Part Number	D353515
This Issue	9/12/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3535 REV B
First Issue	N/A	Project Number	N/A
Previous Run	32737	Drawing Revision	B
Written By	HJ 07-09-12		
Checked & Approved By			
Comment	Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
	Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s) 304/316 .040 Sheet (M304S20GA)	
	Batch: m165824	IB 07-10-2
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B	IB 07-10-2
	Prog Rev: B	(29)
	2-Deburr if necessary	IB 07-10-2
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	IB 07-10-2
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	W 07/10/03 (29) counts
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15	SB 07/10/03 (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:14:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARSHOE
Job Number: 34624		Part Number: D353515
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>coatings</i>
Comment: INSPECT WORK TO CURRENT STEP		<i>En 07/10/03 X28</i>
7.0	POWDER COATING	POWDER COATING <i>M104846</i>
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		<i>07-10-04 X29</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>29IX</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>m/f 07/10/04</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>29IX</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>F.P. 15</i>		<i>m/f 07/10/04</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE <i>29</i>
Comment: FINAL INSPECTION/W/O RELEASE		<i>107/10/04</i>
Job Completion		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34624
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1

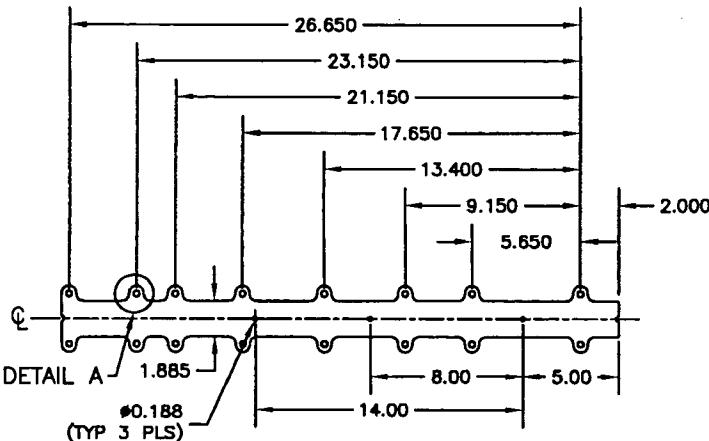
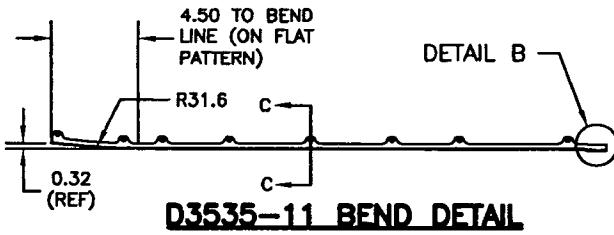
### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

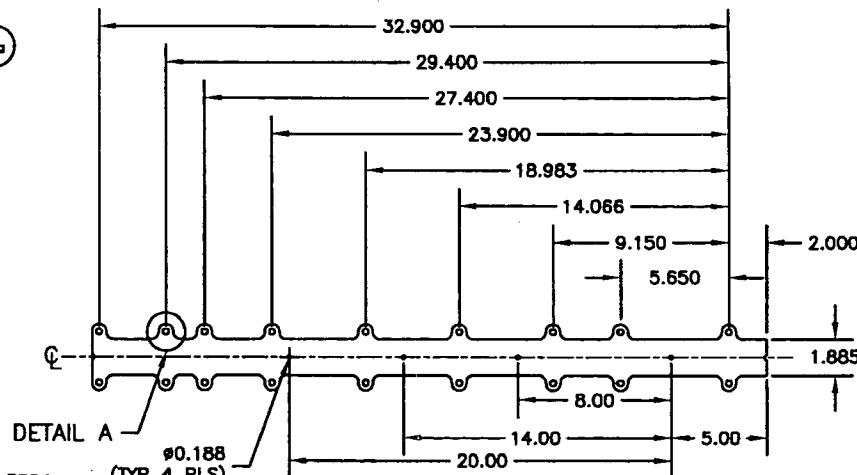
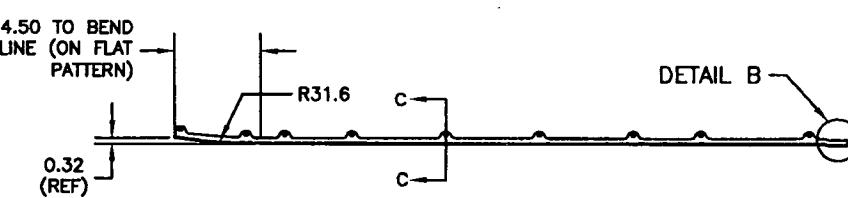
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2.000	+/-0.010	2.000	X			
5.650	+/-0.010	5.650	X			
9.150	+/-0.010	9.150	X			
14.400	+/-0.010	14.400	X			
19.650	+/-0.010	19.650	X			
24.900	+/-0.010	24.900	X			
30.150	+/-0.010	30.150	X			
33.650	+/-0.010	33.650	X			
35.650	+/-0.010	35.650	X			
39.150	+/-0.010	39.150	X			
Ø0.188	+0.005/-0.001	.191	X			
24.00	+/-0.030	24.00	X			
16.00	+/-0.030	16.00	X			
8.00	+/-0.030	8.00	X			
5.00	+/-0.030	5.00	X			
0.300	+/-0.010	.302	X			
0.300	+/-0.010	.303	X			
0.038	+/-0.010	.036	X			

Measured by:	R	Audited by:	CW	Prototype Approval:	N/A
Date:	07-10-2	Date:	2010	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	EZ

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

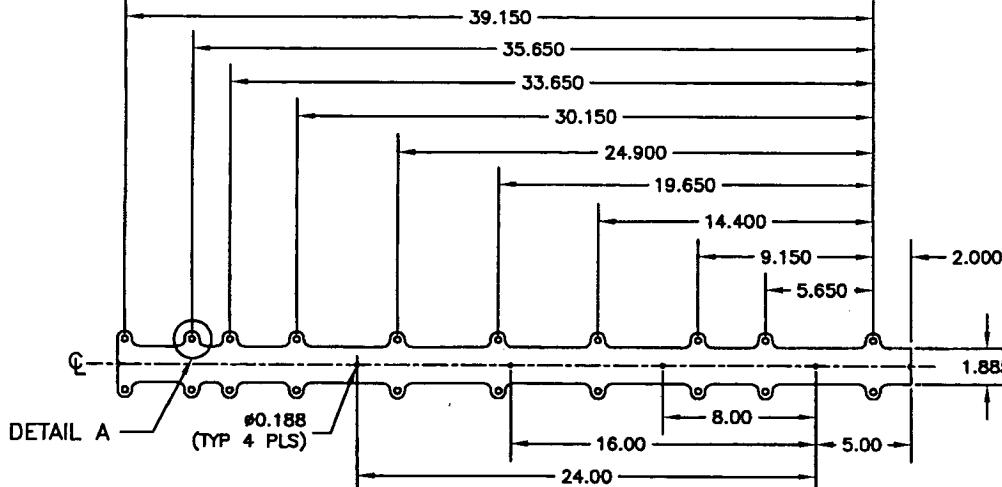
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WITHOUT NOTICE  
WORK ORDER  
NO. 3535-11

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	P.H	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
07.04.17		WEARSHOE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

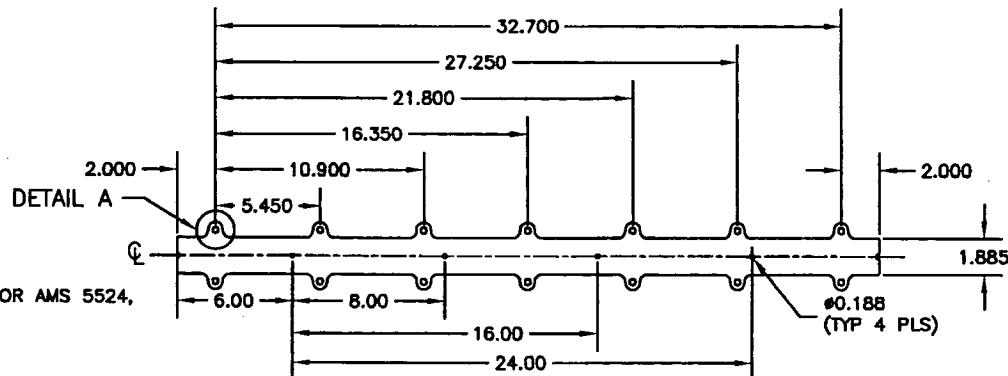
REV. B  
SHEET 1 OF 7  
SCALE 1:10

NO. 34624

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)0.32  
(REF)UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDERSHOP COPY  
RETURN TO  
ENGINEERING**D3535-15F FLAT PATTERN**RELEASED  
07.04.24**DART**

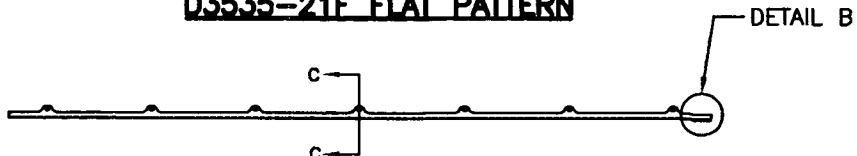
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	MH	PORT HADLOCK, WA
CHECKED	MH	DRAWING NO.
DATE	07.04.17	TITLE

REV. B  
SHEET 2 OF 7  
SCALE 1:10

**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**

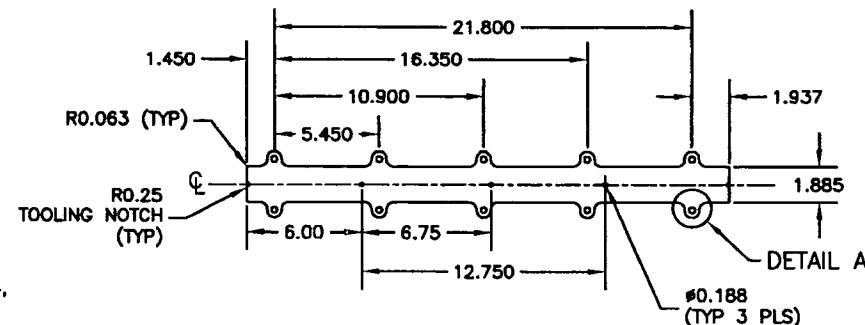
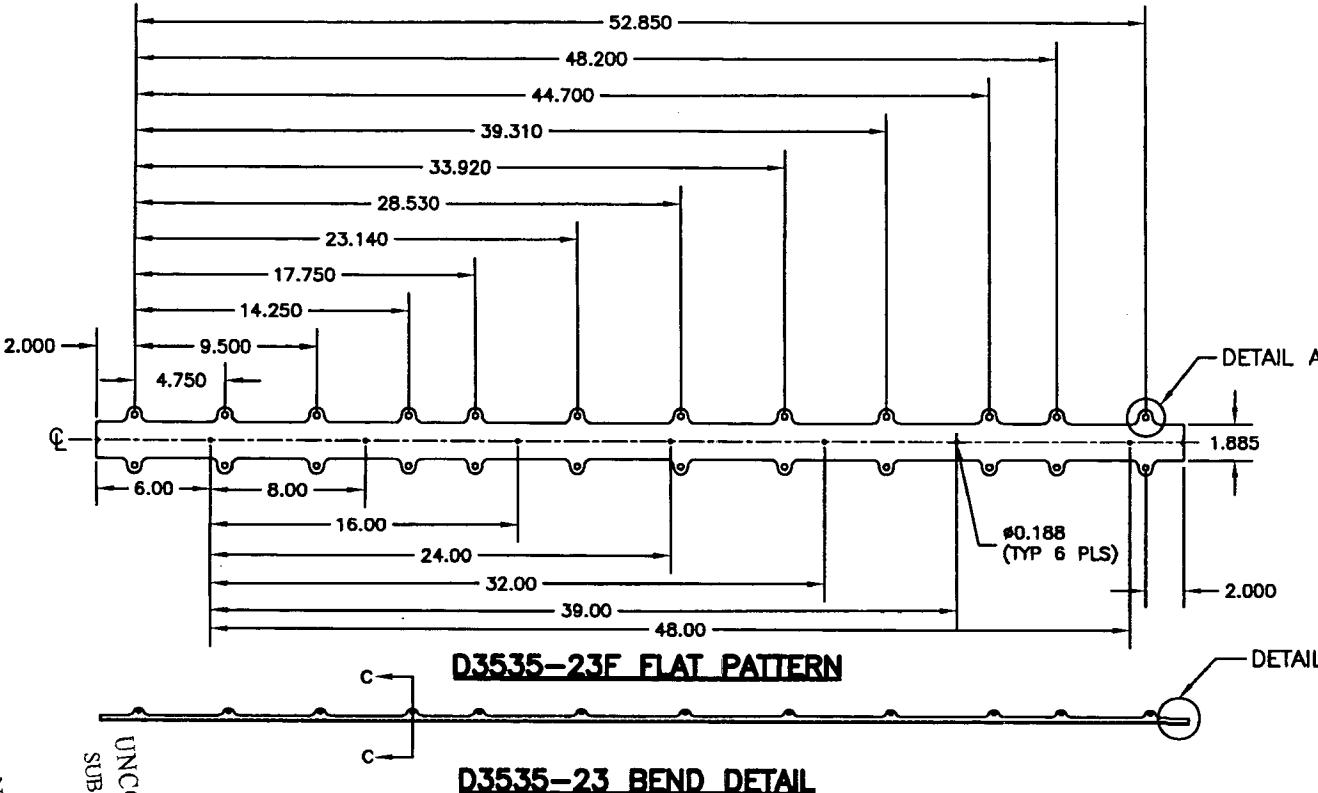
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21 BEND DETAIL**

**DART**

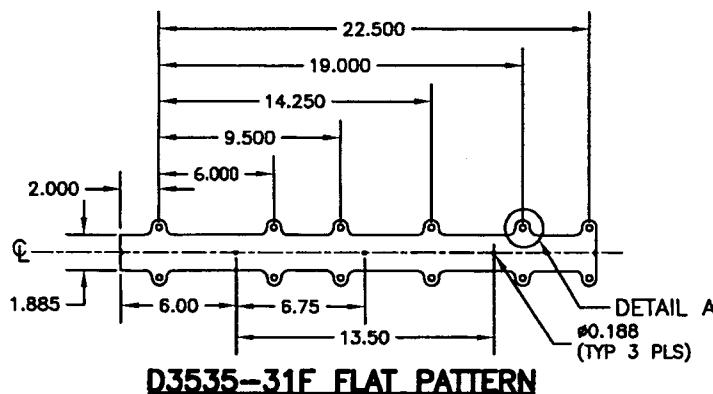
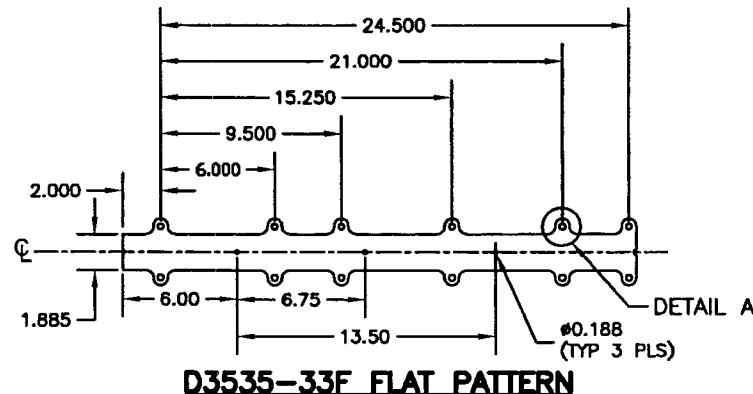
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CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B
SCALE 1:10	SHEET 3 OF 7	

RELEASED  
07.04.24 *M***D3535-25 BEND DETAIL**

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NO *34624*

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**RELEASED  
07.04.17**D3535-31 BEND DETAIL****D3535-33 BEND DETAIL**

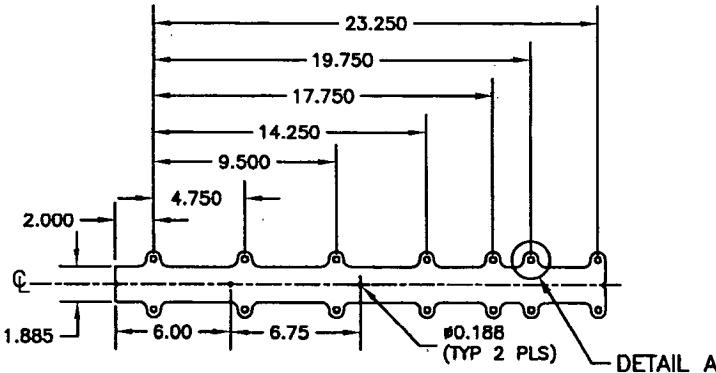
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<b>CB</b>	<b>PH</b>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		SHEET 4 OF 7
07.04.17		SCALE
		1:10
	TITLE	
	WEARSHOE	

**NOTES**

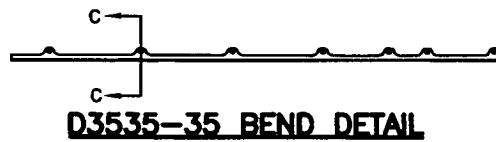
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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WITHOUT NOTICE  
WORK ORDER  
NO 24624



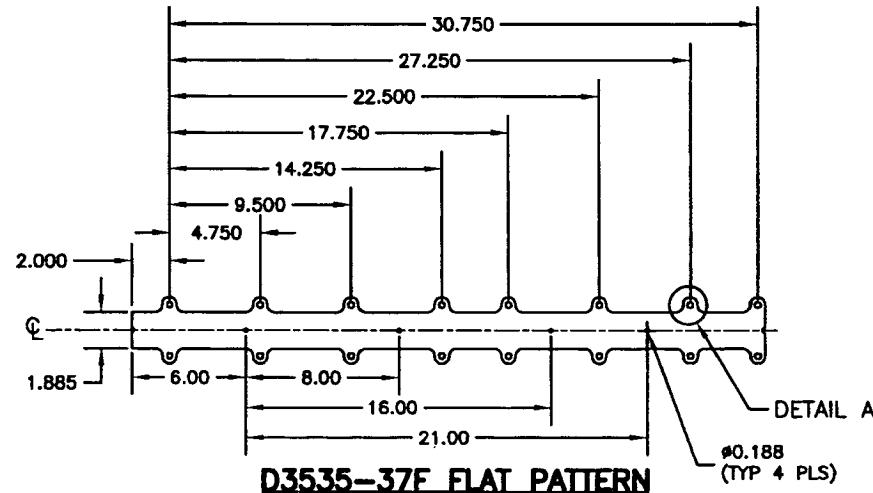
**D3535-35F FLAT PATTERN**



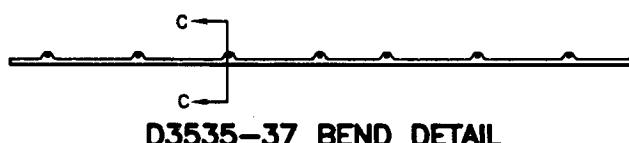
**D3535-35 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
C.B	P.H.	DRAWING NO. D3535	SHEET 5 OF 7
CHECKED	APPROVED	TITLE WEARSHOE	SCALE 1:10
DATE 07.04.17			

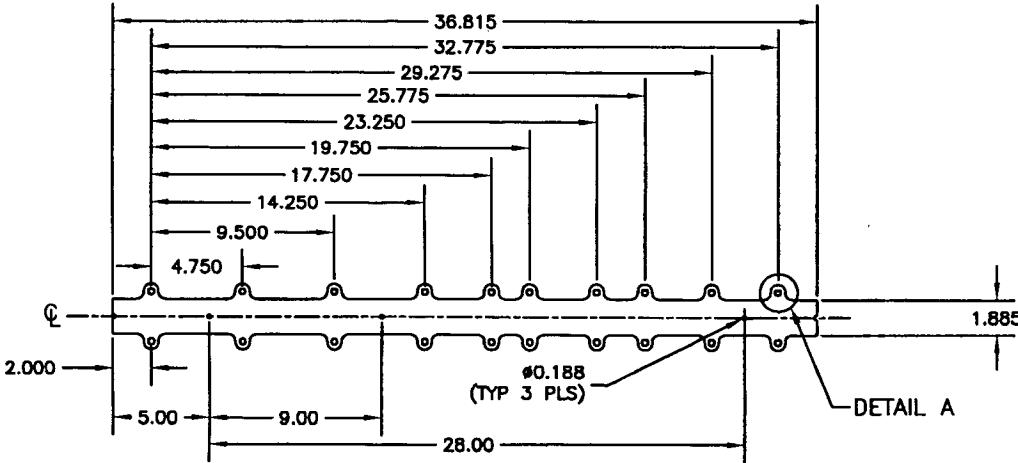
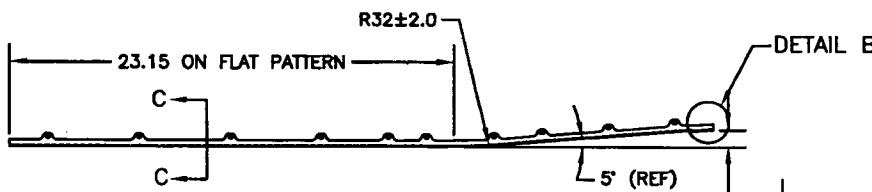
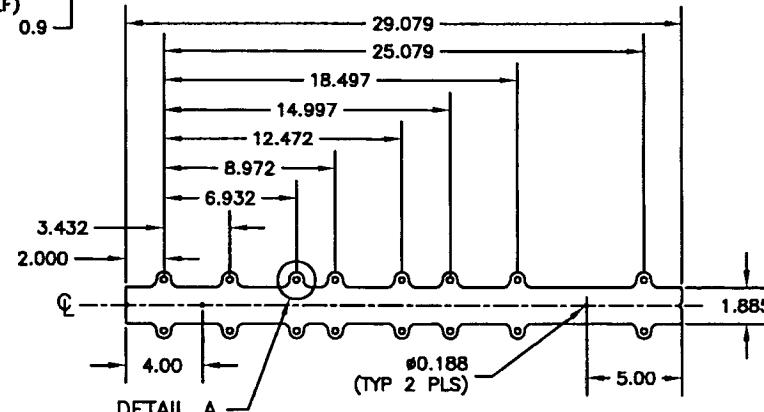
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07.04.24

**DART**

**DART**

DESIGN C.B	DRAWN BY <i>MH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>MF</i>	APPROVED <i>MH</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7 SCALE 1:10

RELEASED  
07.04.24  
*[Signature]*

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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NO. 34624

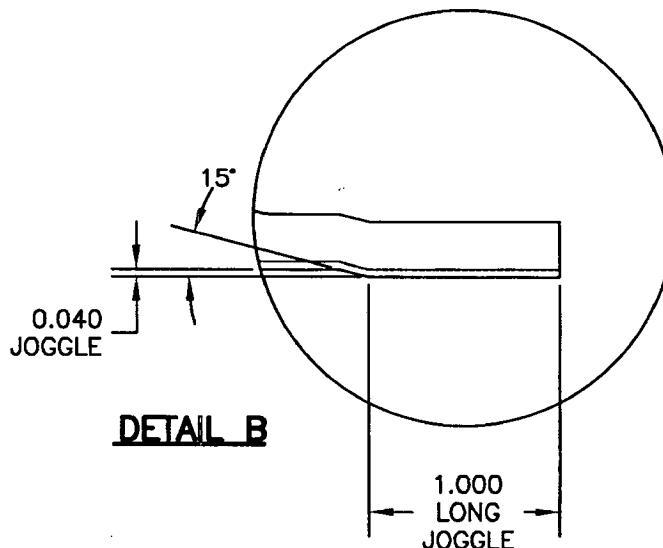
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

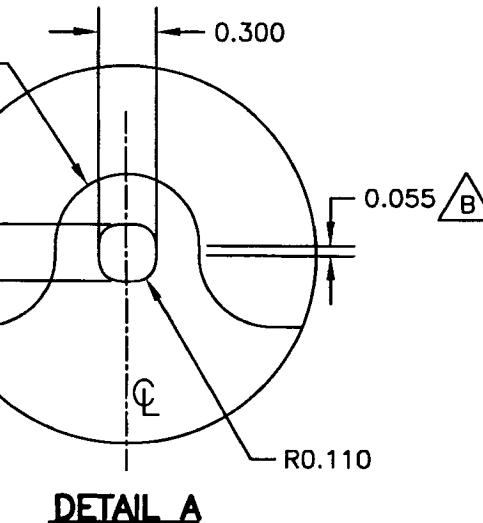
**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 7 OF 7 SCALE <b>1:1</b>

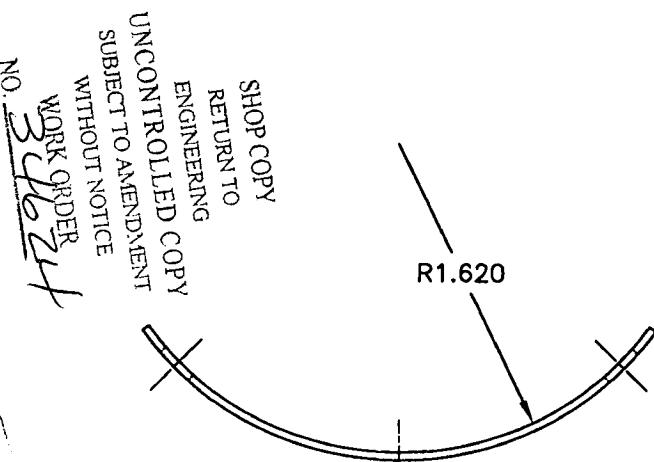
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07.04.24



DETAIL B



DETAIL A



SECTION C-C

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